

Date: Tuesday, 01/04/2008 10:28:04 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW
Job Number	: 38266		
Estimate Number	: 10003		
P.O. Number	:	Part Number	: D2214
This Issue	: 01/04/2008 S.O. No. :	Drawing Number	: D2214 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL / MED FAB	Drawing Revision	: C
Previous Run	: 34526	Material	:
Written By	: <u>07.07.01.</u>	Due Date	: 08/04/2008 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:C 99.04.29 Added New Jig and Part Numbers DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 0.7960 sf(s)/Unit Total : 7.9600 sf(s)

1/8" Polycast Sheet

(M-acrylic-S.125)

BATCH: 10674 B 8-4-2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2214

Dwg Rev: C B 8-4-2

Prog Rev: C

2-Debur if necessary

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-4-2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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no ~~in~~ cracks or defects

few



Comment: SECOND CHECK

50/04/02 (10)

5.0	D27281	Dart Logo label small
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2728-1	DART logo	<u>B24215</u>

08/04/03

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 38266

Part Number: D2214

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2462

Neoprene Seal



Comment: Qty.: 3.6700 f(s)/Unit Total : 36.7000 f(s)
Neoprene Seal



Pick:

Qty Part Number Description
44" D2462 SEAL

Batch

B29456

B08/04/03

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2462 Seal to length and Install around edge

2-Transfer holes through seal

3-Attach small DART logo labels D2728-1as per template DT 8223

PTU

B08/04/03 (8)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

B08/04/03 (48)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Wrap window in cellophane wrap

B08/04/03 (8)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Wrap in foam

Identify and Stock

Location: 9/8

8/4/4

56

(8x)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

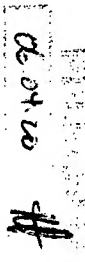
B08/04/04

Job Completion



W mf

08-04-04



Technical drawing of a rectangular plate with the following dimensions and tolerances:

- Overall width: 13.50
- Overall height: 8.50
- Top edge: 6.938 (distance from left edge to first hole center), 0.313 (hole diameter), 0.344 (distance between first and second hole centers), 0.313 (distance from second hole center to right edge).
- Bottom edge: 6.125 (distance from left edge to first hole center), 0.313 (hole diameter), 0.625 (distance between first and second hole centers), 0.625 (distance from second hole center to right edge).
- Left edge: 0.313 (distance from top edge to first hole center), 0.625 (distance from bottom edge to first hole center).
- Right edge: 0.313 (distance from top edge to first hole center), 0.625 (distance from bottom edge to first hole center).
- Internal features: R0.250 (TYP) (fillet radius at top-left corner), $\phi 0.156$ (TYP) (hole diameter).

Handwritten note: u/o 3826

u/o 38266

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 38266		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
08/04/03	7.	2 windows scrap were too much scraper Blow out find By the holes 1 use for new template		Scrap + asst tray No replace Qty (x2)	 08/04/03	 08/04/03	 GSE 42	 08/04/03
		RC from peeling from water st. mat - →						

Part No: D2214 PAR #: N/A Fault Category: Proffing. as med & small NCR: Yes No DQA: D Date: 08/04/04
 NOTE: Date & initial all entries QA: N/C Closed: D Date: 08/04/04